Springfield M1903 Rifle

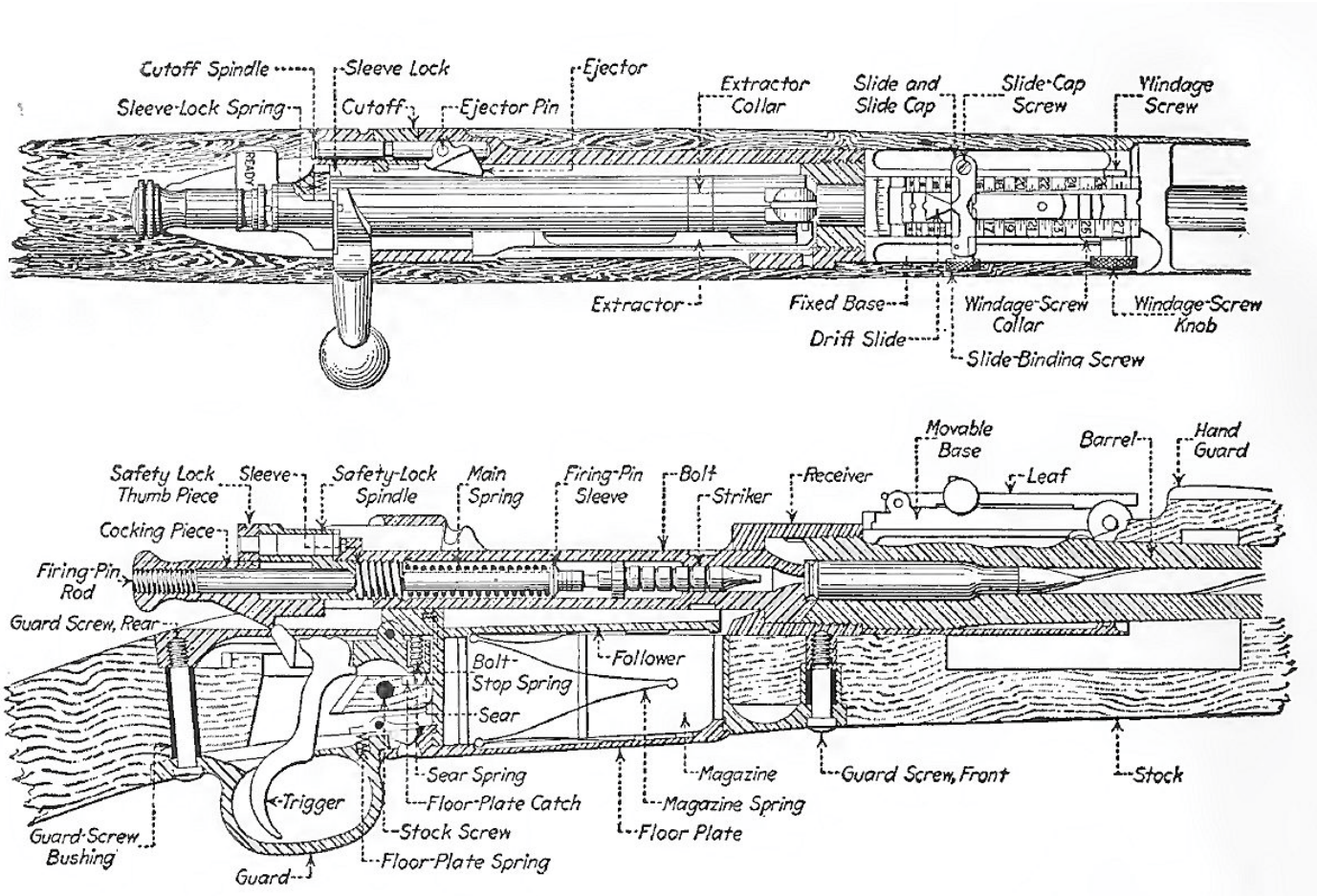


FIG. 26. SECTIONAL VIEW, BOLT AND MAGAZINE MECHANISM, U. S. MAGAZINE RIFLE, MODEL 1903

Drawings not in scale

Some parts are missing

Compilation © Walther38 2013

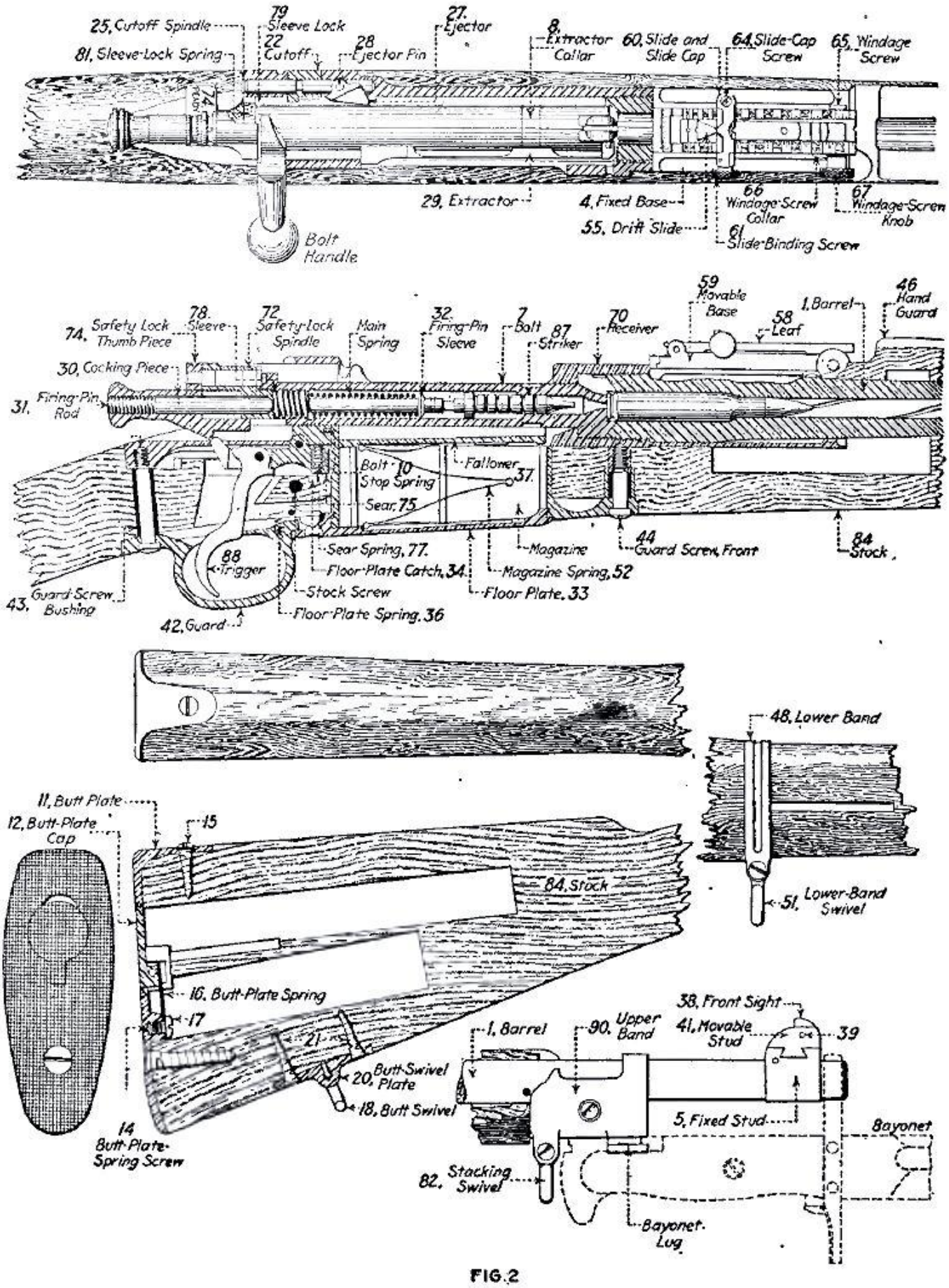


FIG. 2

FIG. 2. SECTIONS OF SPRINGFIELD MODEL 1903 SERVICE RIFLE WITH PARTS NUMBERED FOR IDENTIFICATION

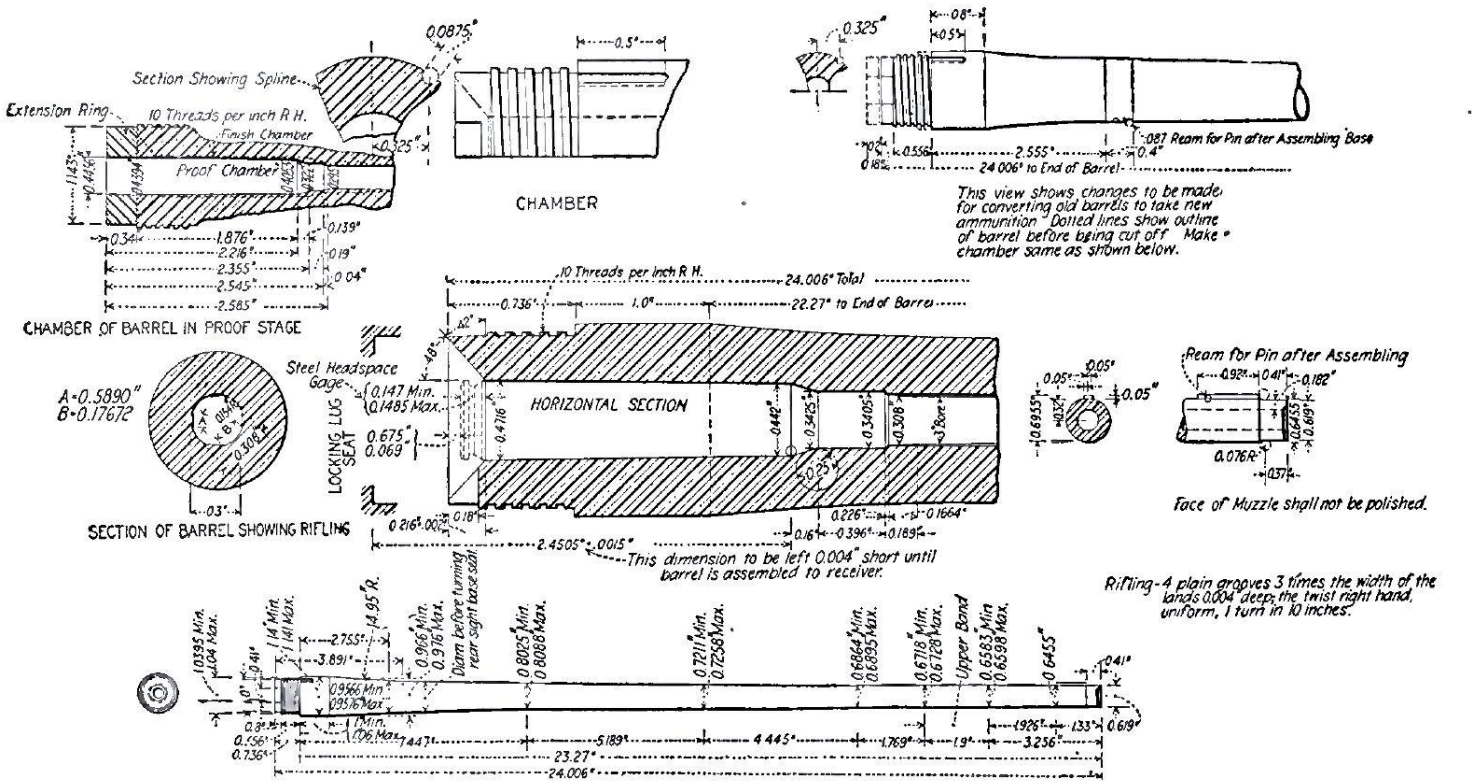

Section Showing Spline
Extension Ring
10 Threads per inch R H.
Finish Chamber
Proof Chamber
CHAMBER
CHAMBER OF BARREL IN PROOF STAGE
This view shows changes to be made for converting old barrels to take new ammunition. Dotted lines show outline of barrel before being cut off. Make chamber same as shown below.
24 006" to End of Barrel
Ream for Pin after Assembling
Steel Headspace Gage
LOCKING LUG SEAT
HORIZONTAL SECTION
A-0.5890"
B-0.17672
SECTION OF BARREL SHOWING RIFLING
This dimension to be left 0.004" short until barrel is assembled to receiver.
Face of Muzzle shall not be polished.
Rifling-4 plain grooves 3 times the width of the lands 0.004" deep; the twist right hand, uniform, 1 turn in 10 inches.
Upper Bond

FIG. 9. SECTIONS OF SPRINGFIELD MODEL 1903 RIFLE BARREL, SHOWING WORKING LIMITS AND DIMENSIONS

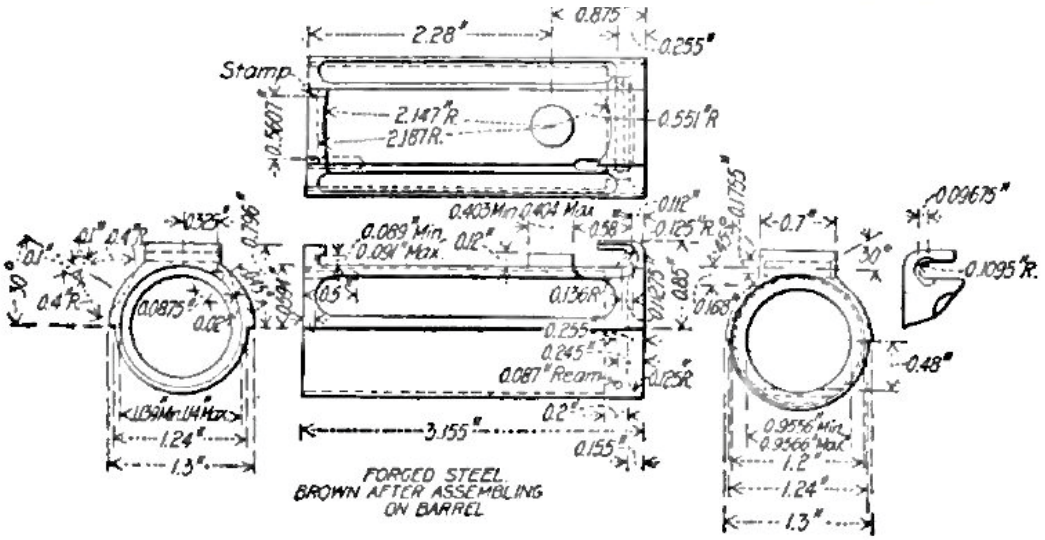
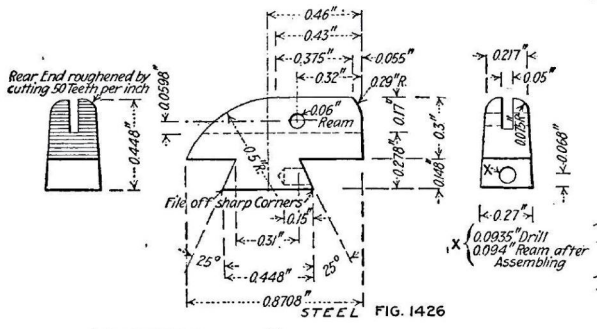


FIG. 157. DETAILS AND WORKING LIMITS O
FIXED BASE



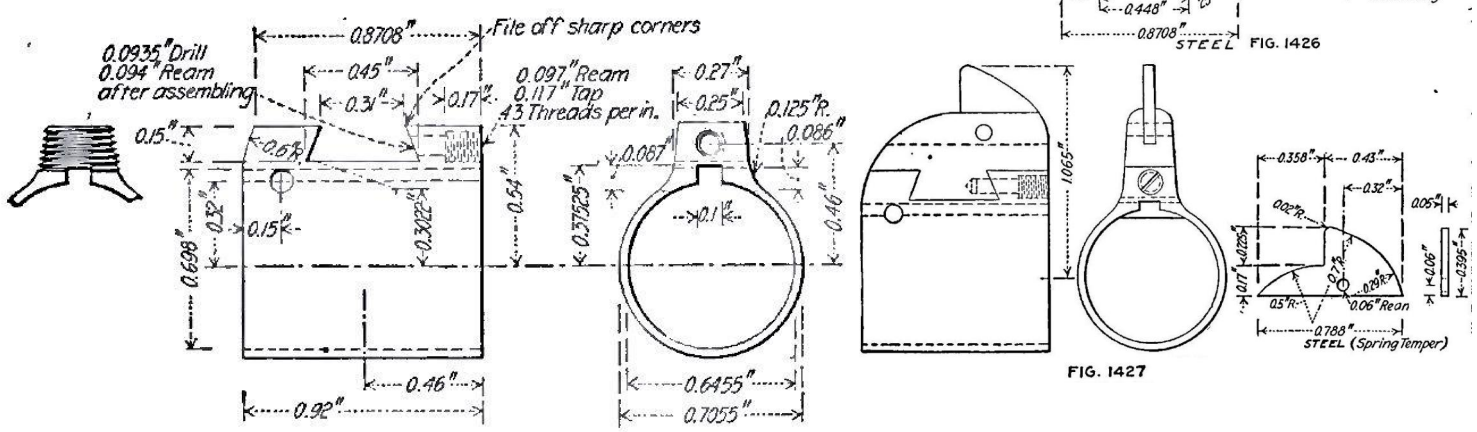


FIG. 106. THE FIXED STUD

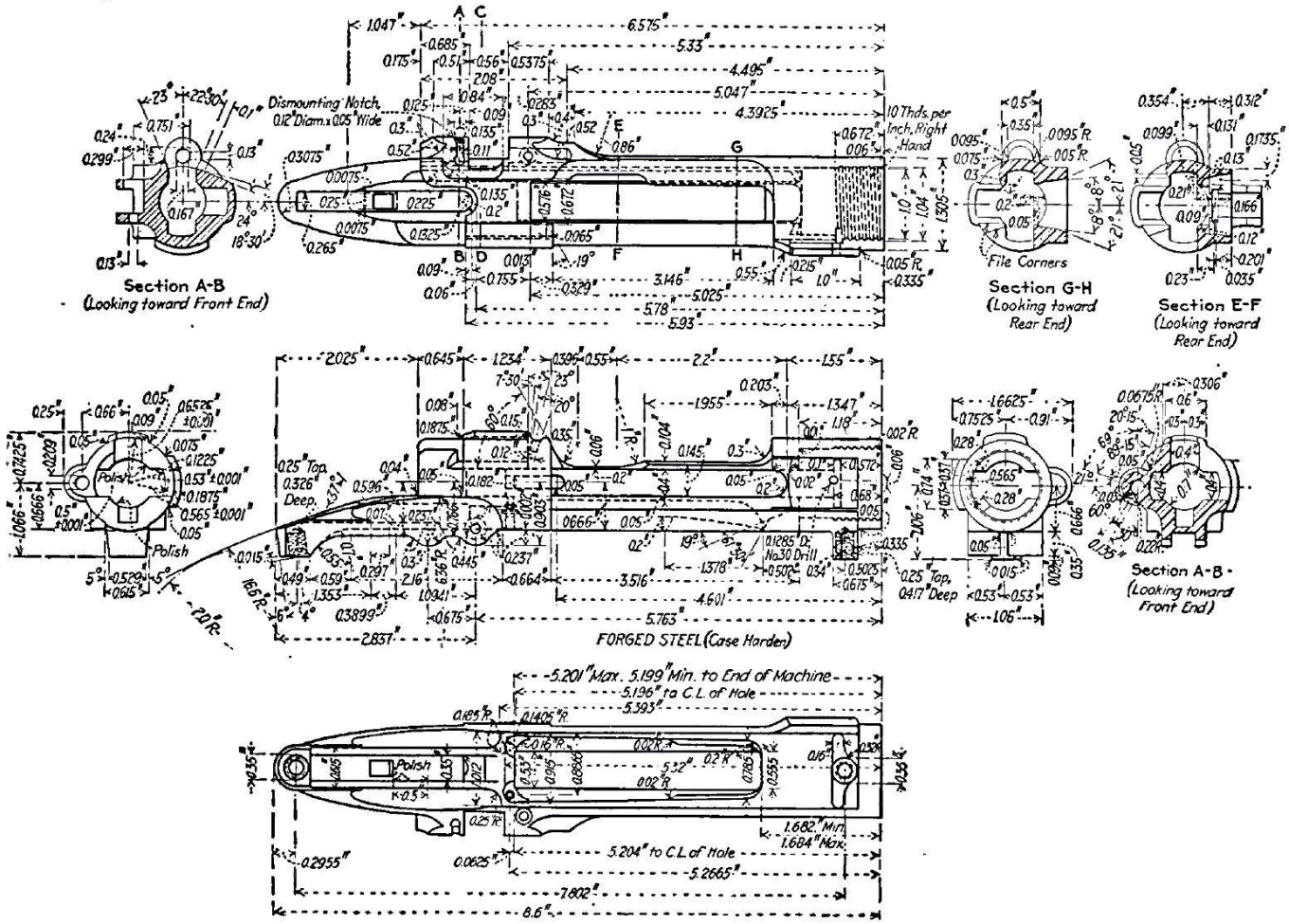


FIG. 251. DETAILS AND WORKING LIMITS OF SPRINGFIELD MODEL 1903 RIFLE RECEIVER

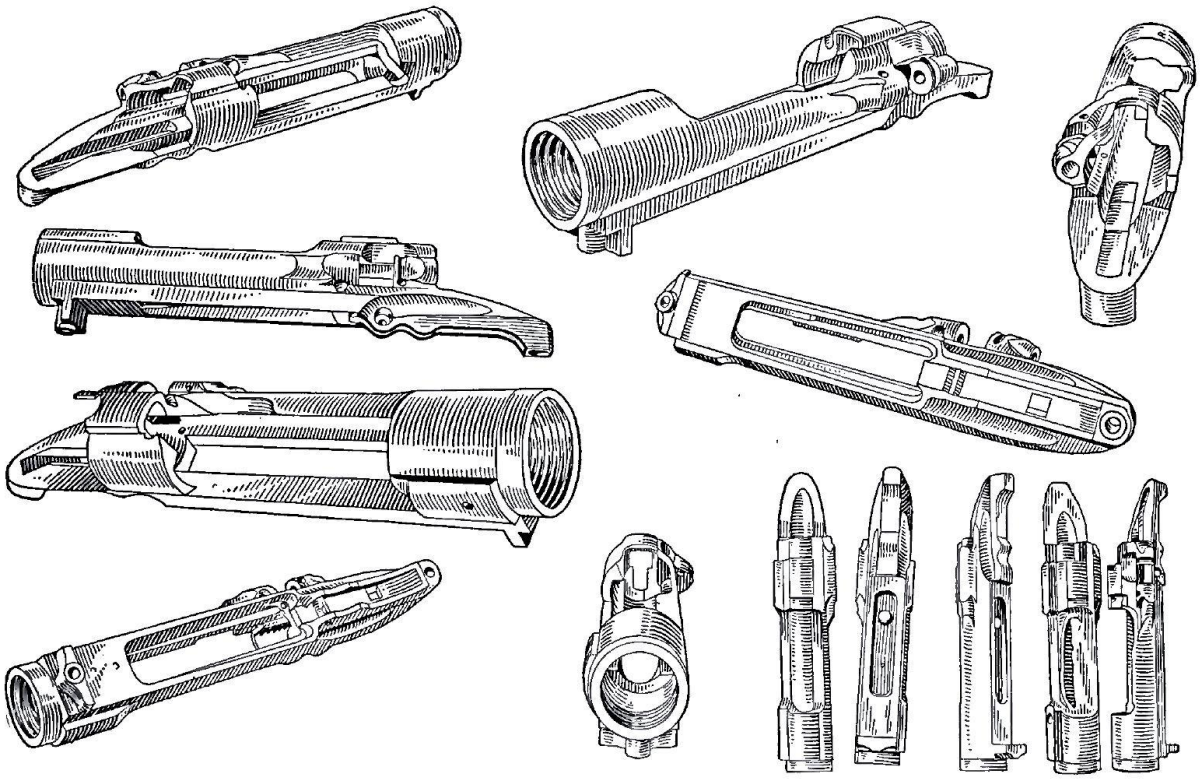


FIG. 245-A. VIEWS OF RECEIVER IN VARIOUS POSITIONS AND STAGES

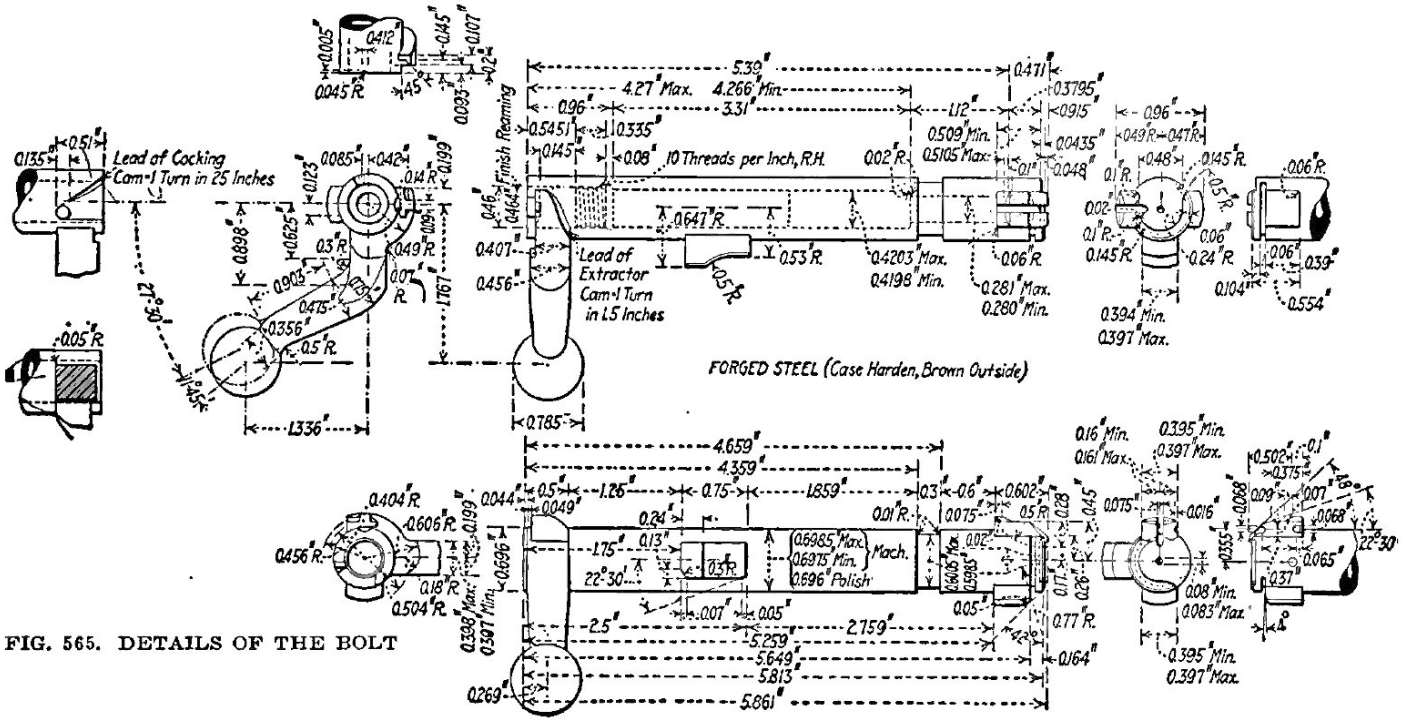
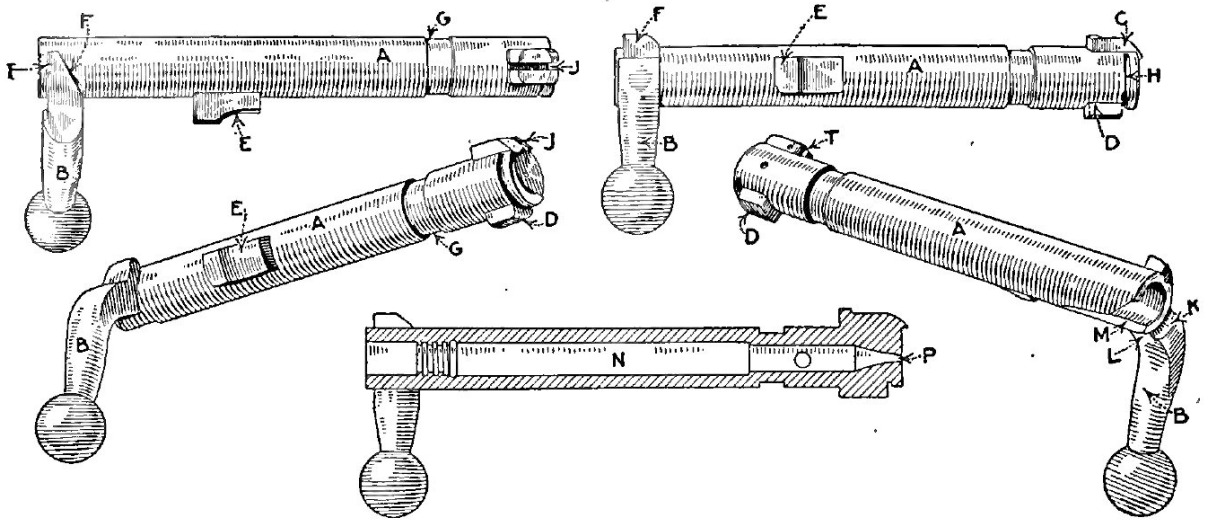
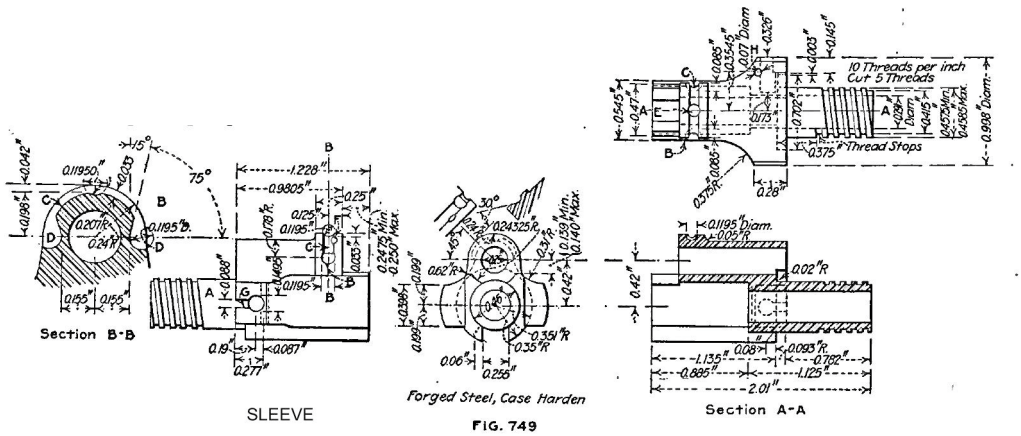

Lead of Cocking Cam-1 Turn in 25 Inches
Finish Reaming
10 Threads per Inch, R.H.
Lead of Extractor Cam-1 Turn in 1.5 Inches
FORGED STEEL (Case Harden, Bronn Outside)
Mach.
Polish

FIG. 565. DETAILS OF THE BOLT



MAIN OPERATIONS ON BOLT



SLEEVE

FIG. 749

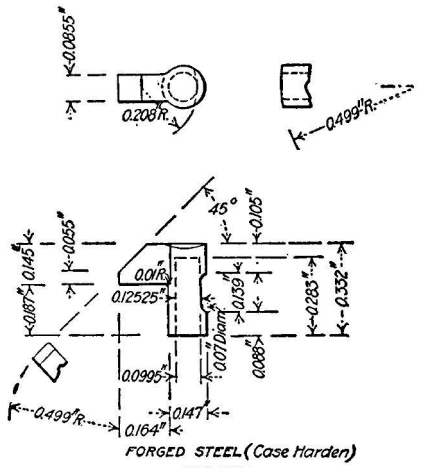


FIG. 855

DETAILS OF SLEEVE LOCK

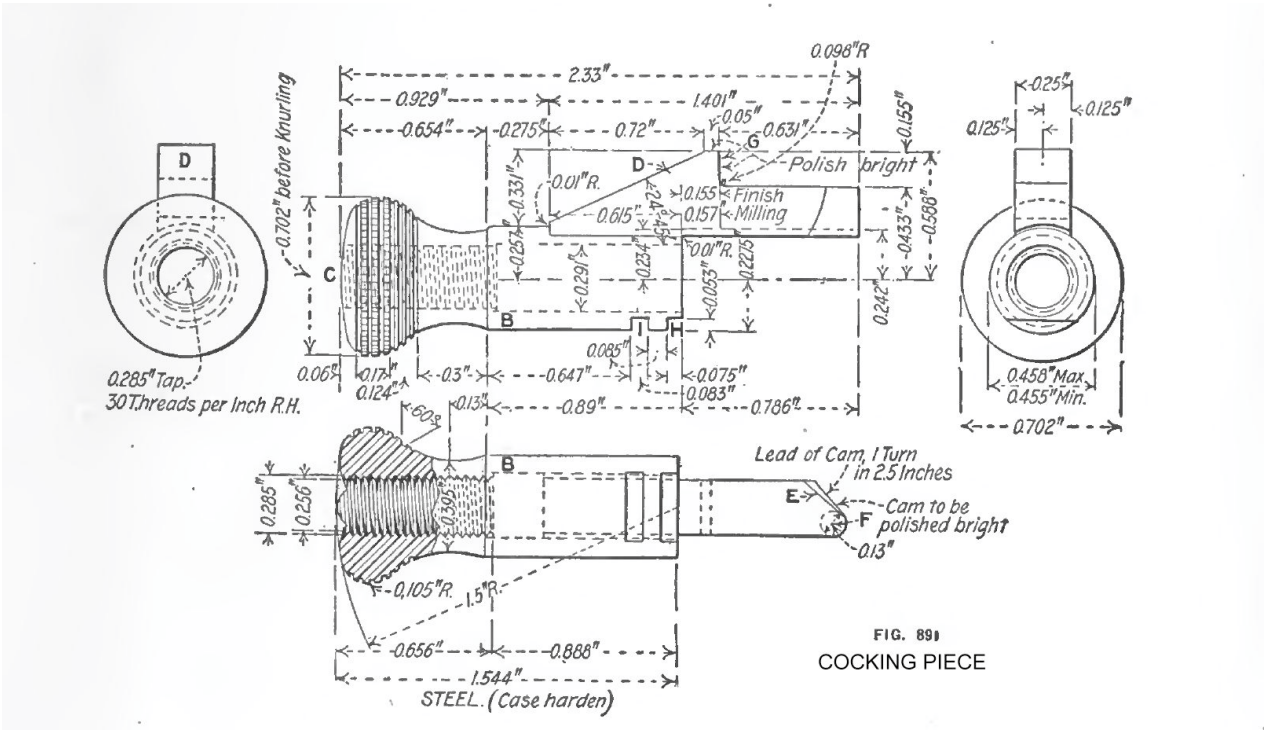


FIG. 891

COCKING PIECE

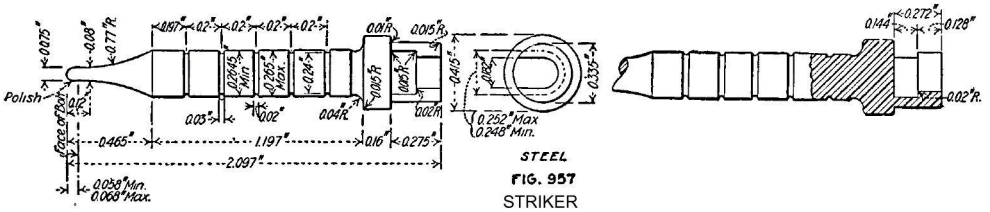


FIG. 957

STRIKER

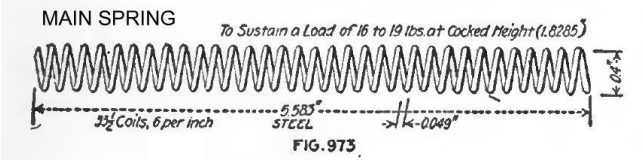
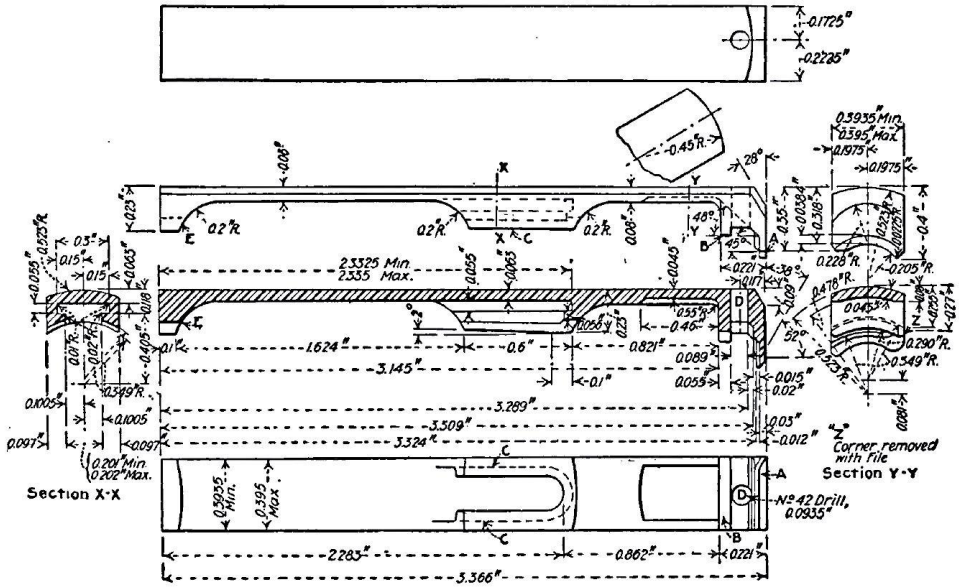


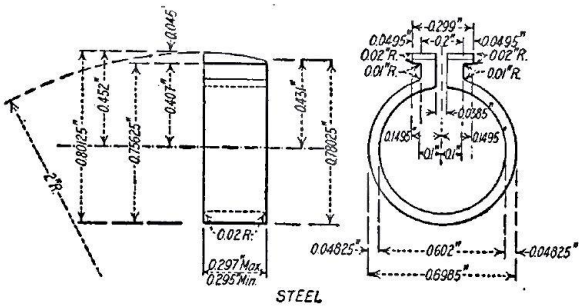
FIG. 973



EXTRACTOR

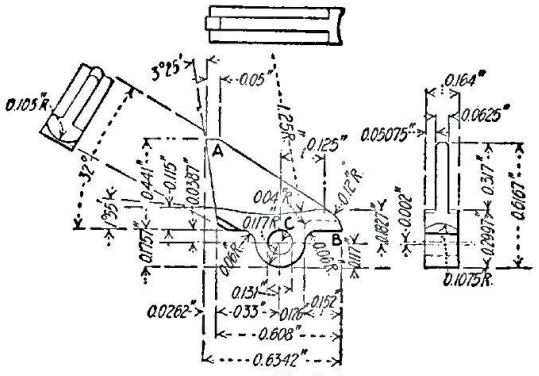
FORGED STEEL

FIG. 977



STEEL

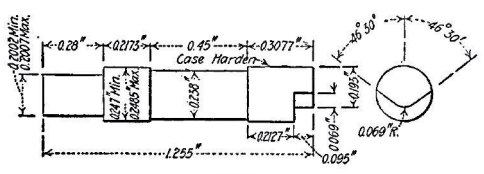
FIG. 1044 EXTRACTOR COLLAR



STEEL (Harden)

FIG. 1064

EJECTOR



STEEL

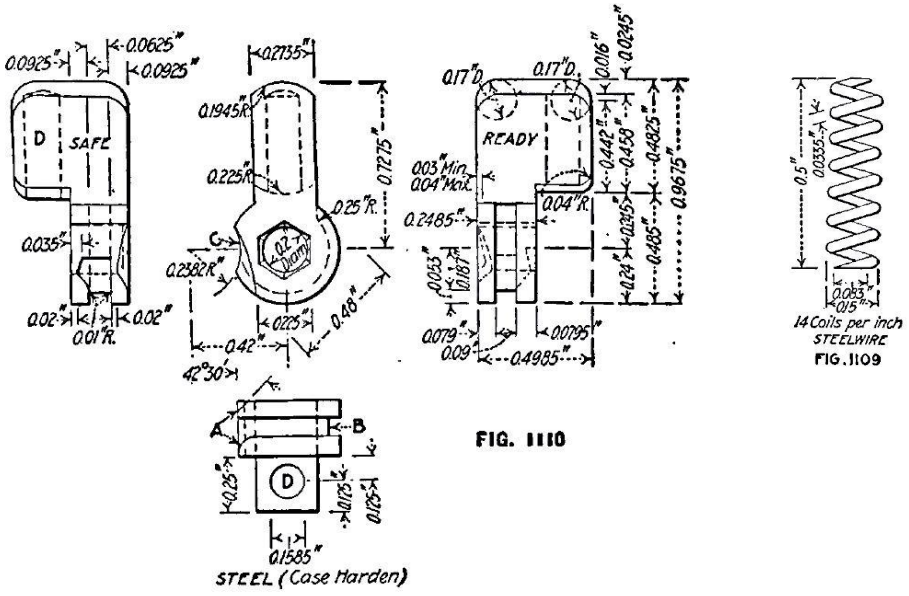


FIG. 1109

FIG. 1110

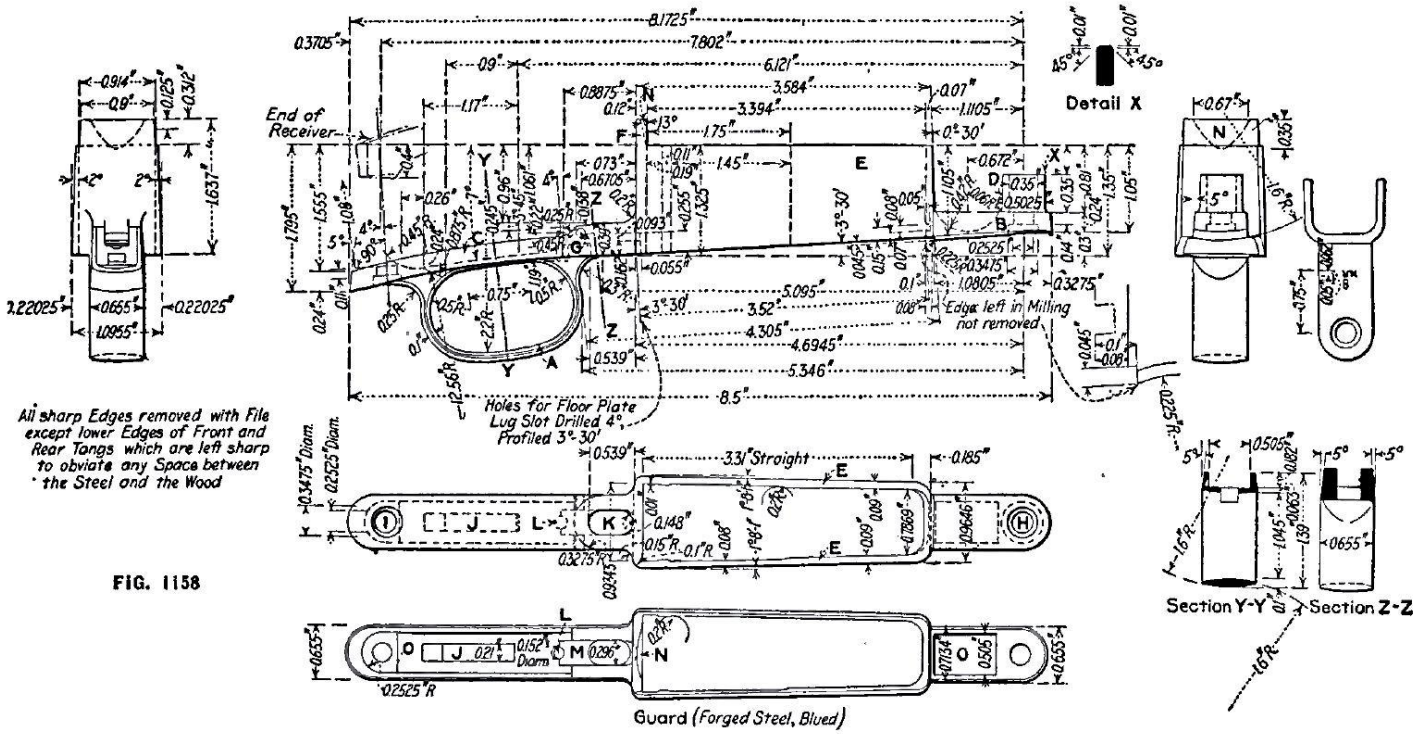

End of Receiver
Detail X
Holes For Floor Plate Lug Slot Drilled 4° Profiled 3°-30'
Edge left in Milling not removed
All sharp Edges removed with File except lower Edges of Front and Rear Tangs which are left sharp to obviate any Space between the Steel and the Wood
Section Y-Y
Section Z-Z
Guard (Forged Steel, Blued)

FIG. 1158

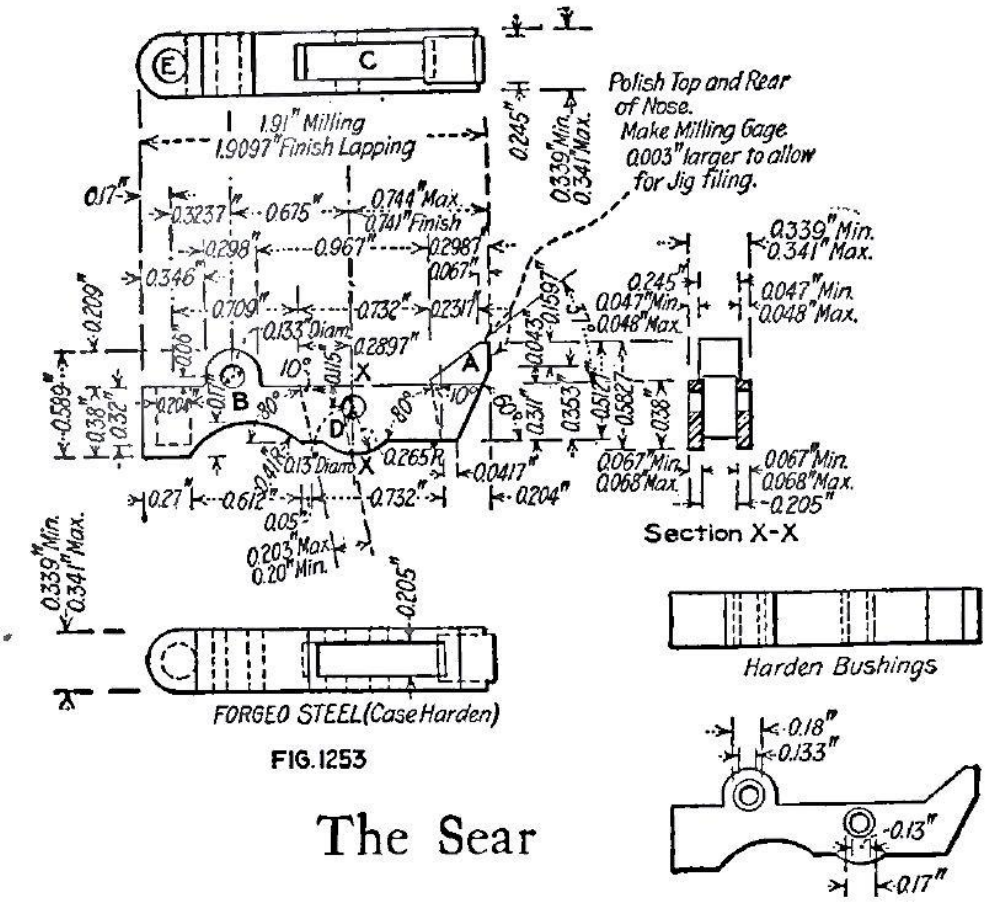

Polish Top and Rear of Nose. Make Milling Gage 0.003" larger to allow for Jig Filing.
1.91" Milling
1.9097" Finish Lapping
Section X-X
Harden Bushings
FORGED STEEL (Case Harden)

FIG. 1253

The Sear

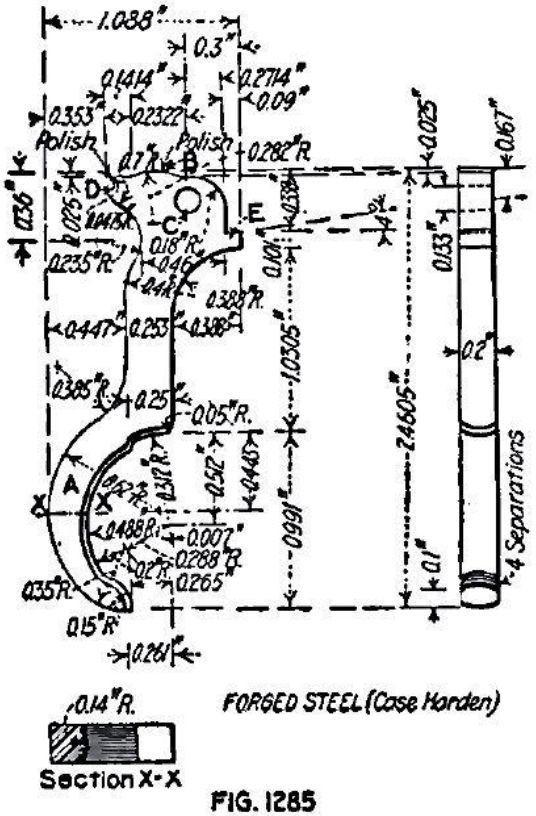


FIG. 1285

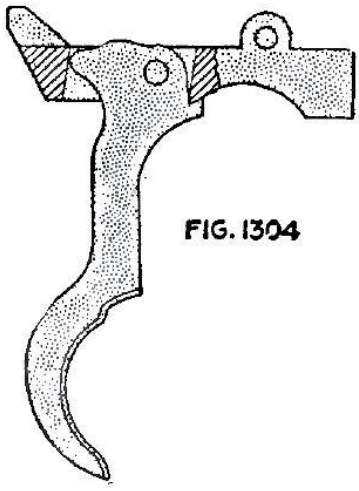


FIG. 1304

The trigger

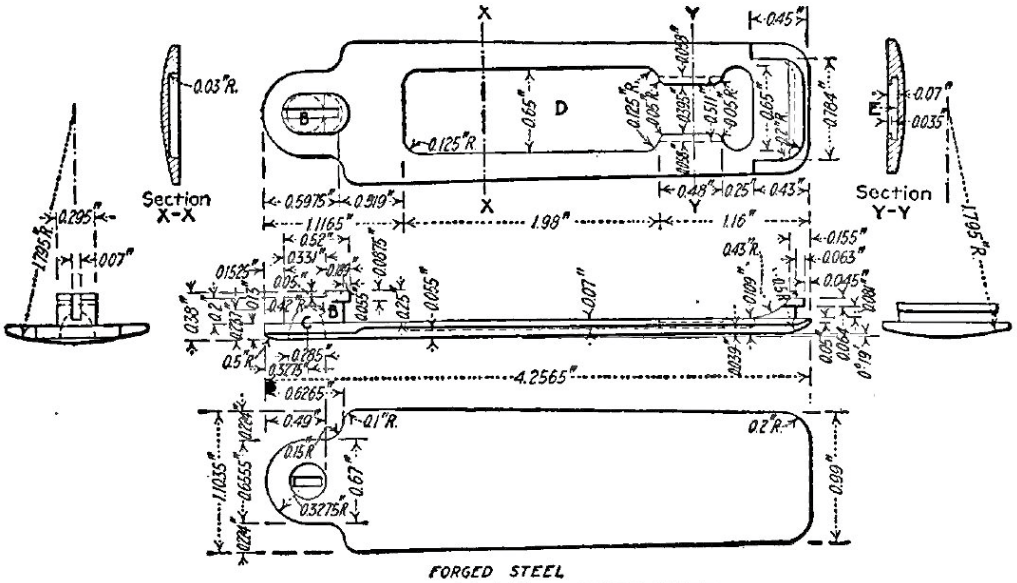
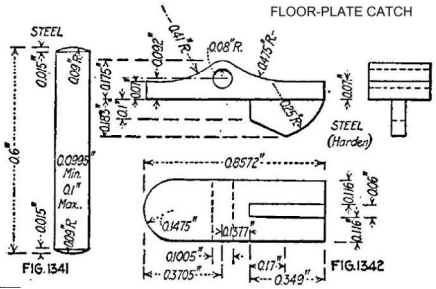


FIG. 1305 FLOOR PLATE

FLOOR-PLATE CATCH



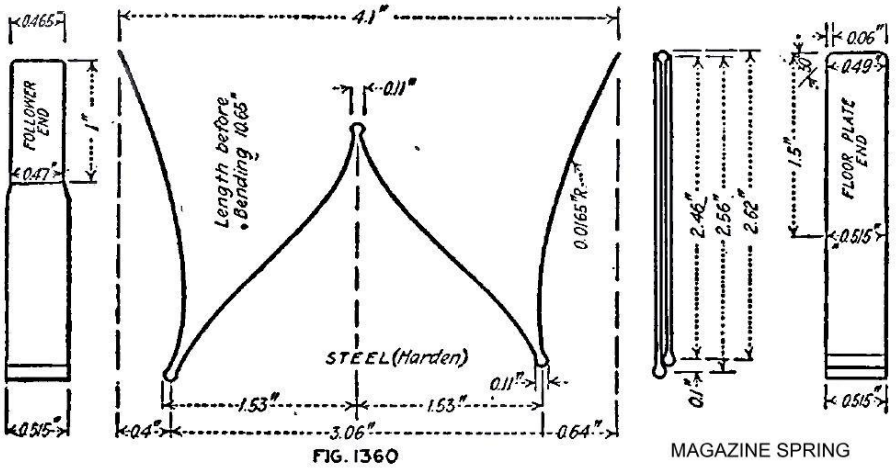


FIG. 1360 MAGAZINE SPRING

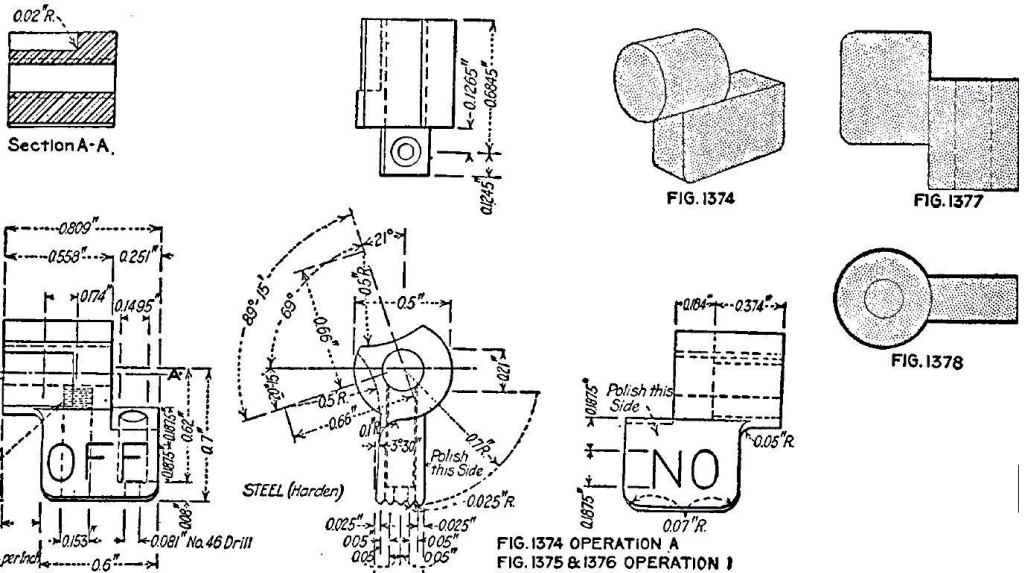
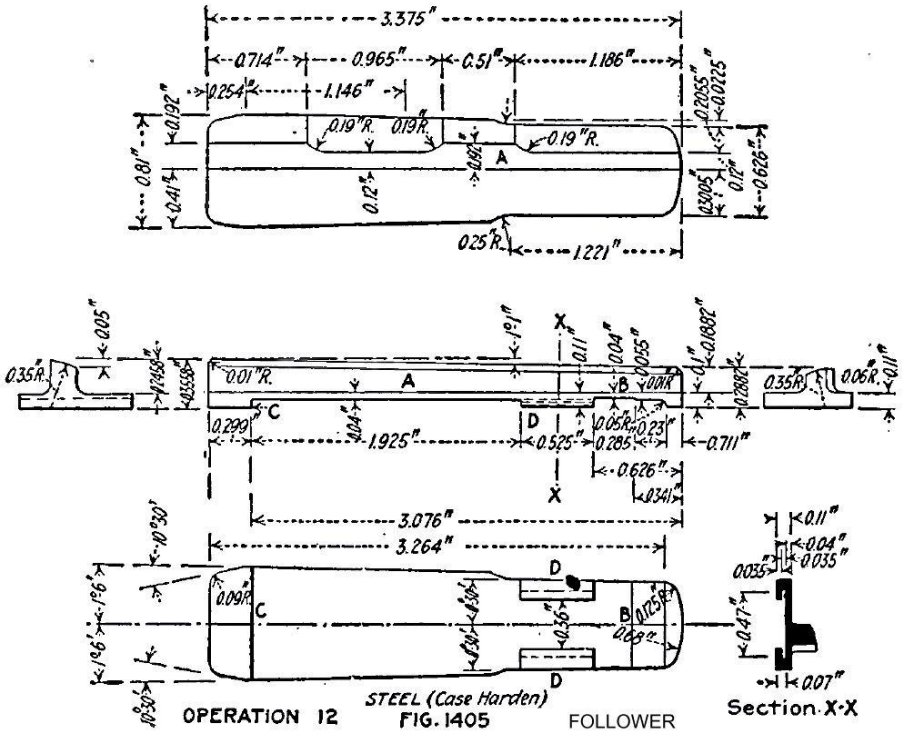


FIG. 1374 FIG. 1377 FIG. 1378

CUTOFF FIG. 1373

FIG. 1374 OPERATION A
FIG. 1375 & 1376 OPERATION 1
FIG. 1377 OPERATION 2
FIG. 1378, 1379, 1380 & 1381 OPERATION 3 & 4



OPERATION 12 FIG. 1405 FOLLOWER

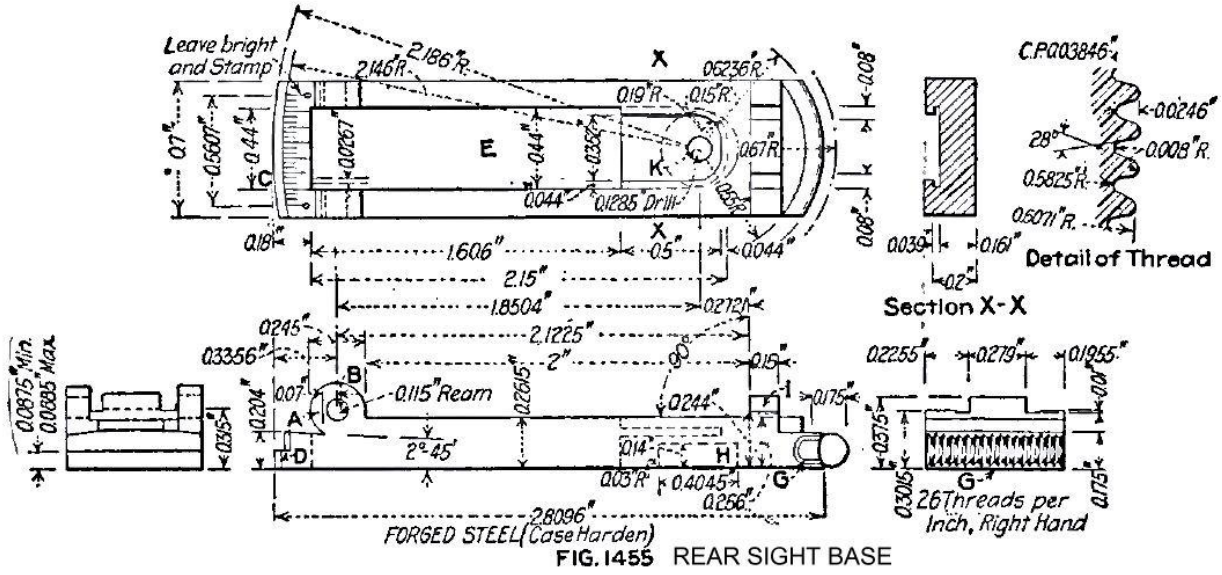


FIG. 1455 REAR SIGHT BASE

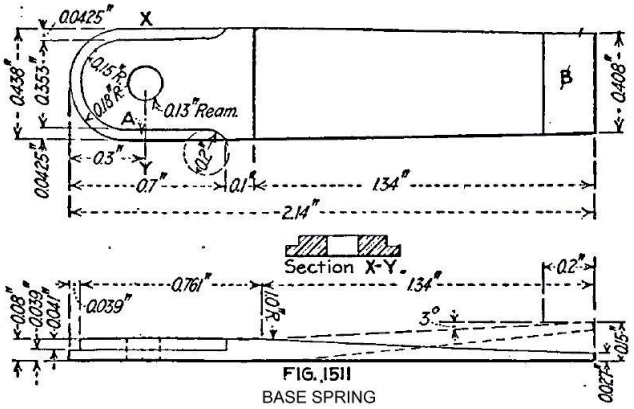


FIG. 1511
BASE SPRING

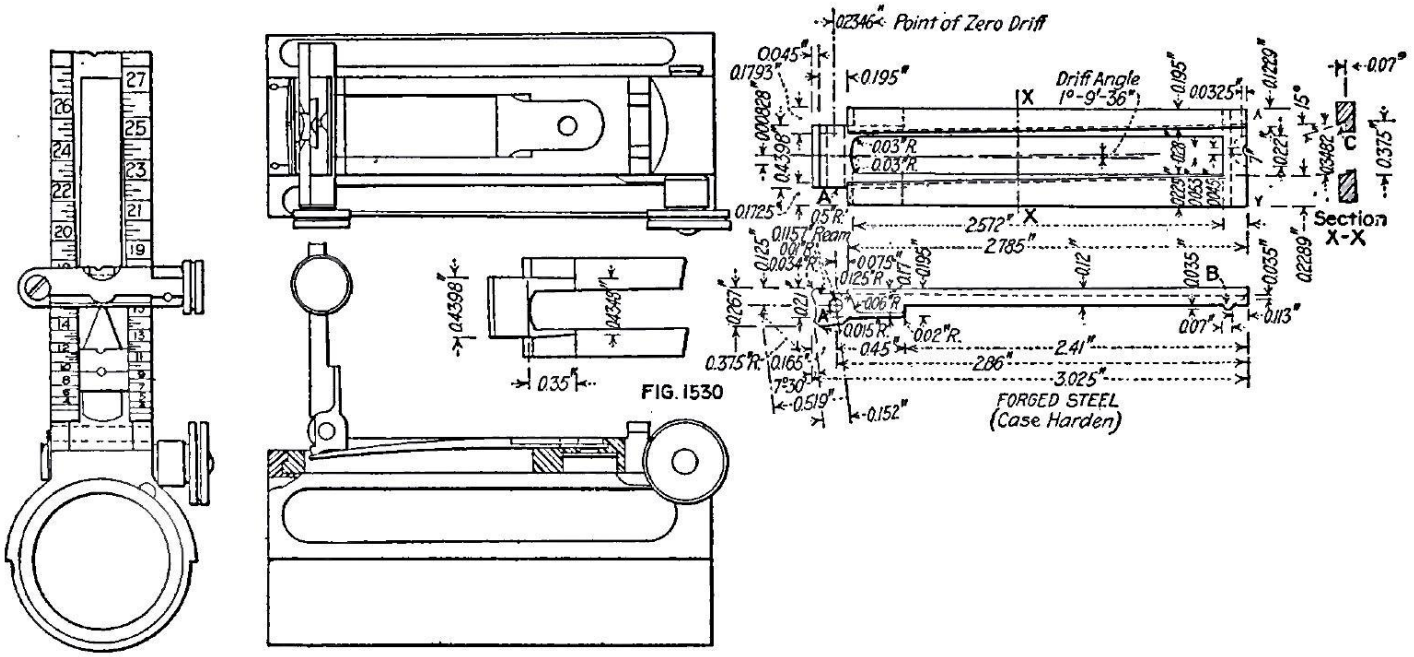


FIG. 1530

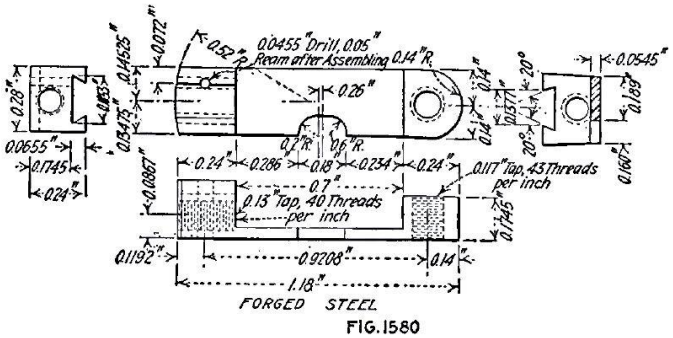


FIG. 1580

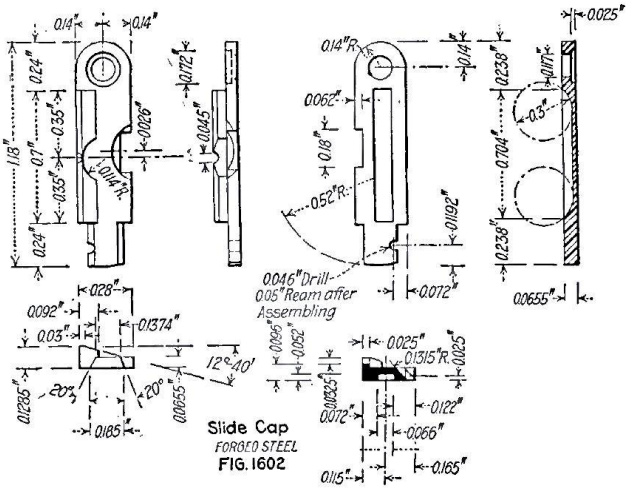


FIG. 1602

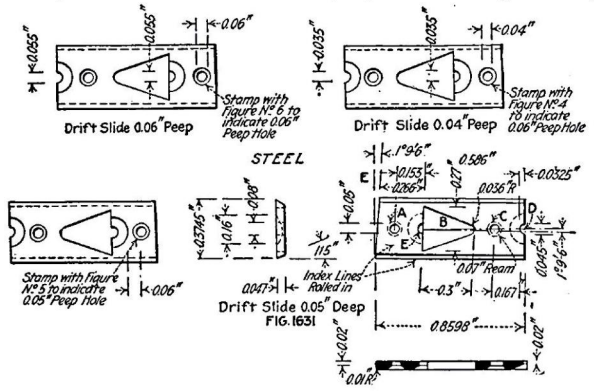

Drift Slide 0.06" Peep
Stamp with Figure No. 6 to indicate 0.06" Peep Hole
Drift Slide 0.04" Peep
Stamp with Figure No. 4 to indicate 0.06" Peep Hole
STEEL
Stamp with Figure No. 5 to indicate 0.05" Peep Hole
Index Lines Rolled in
Drift Slide 0.05" Deep

FIG. 1631

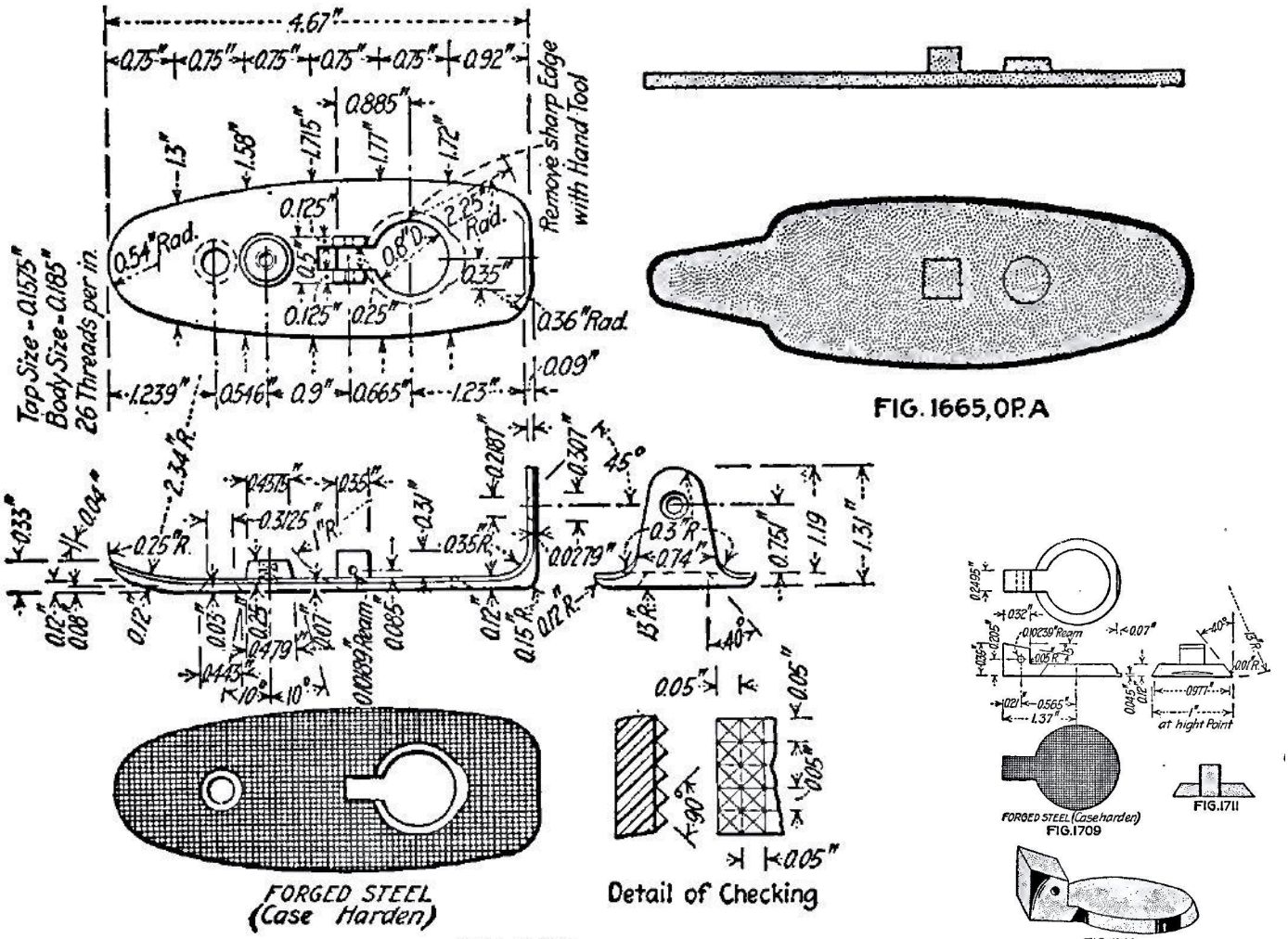


FIG. 1664

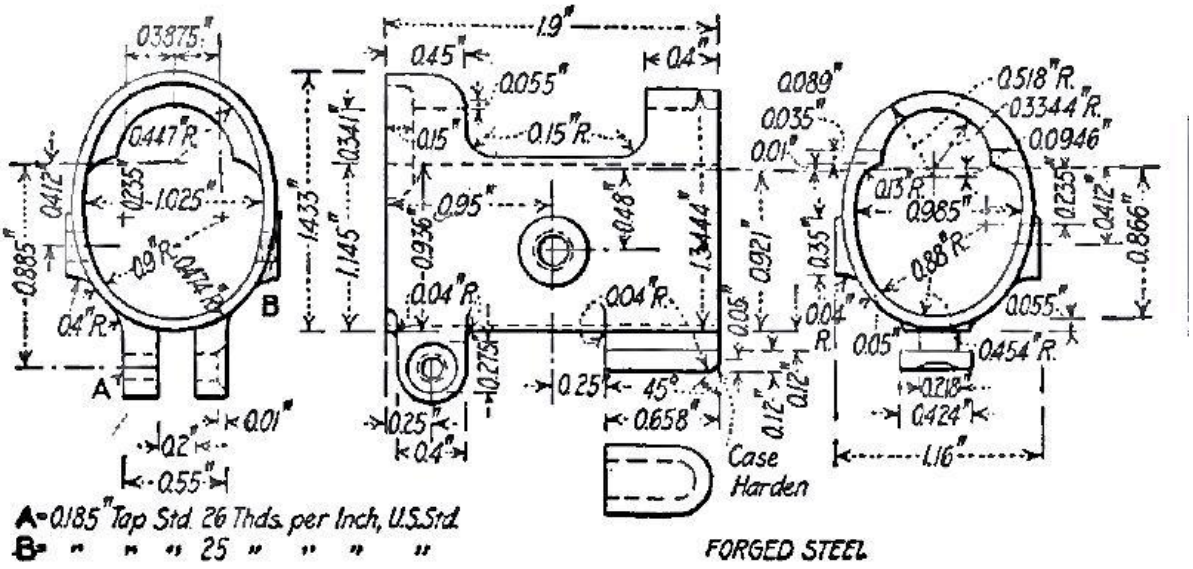


FIG. 1720

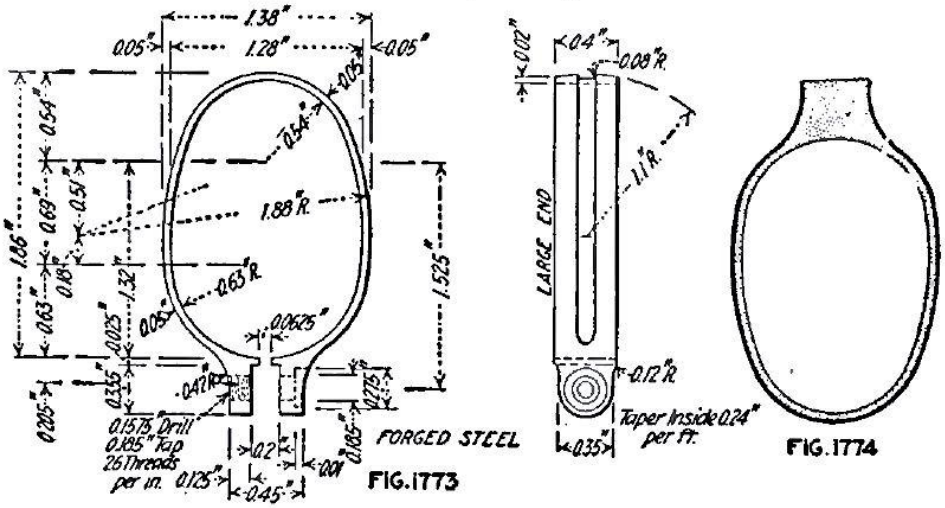


FIG. 1773

FIG. 1774

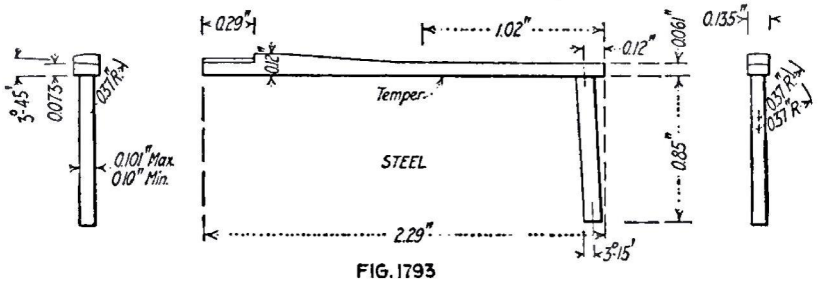


FIG. 1793

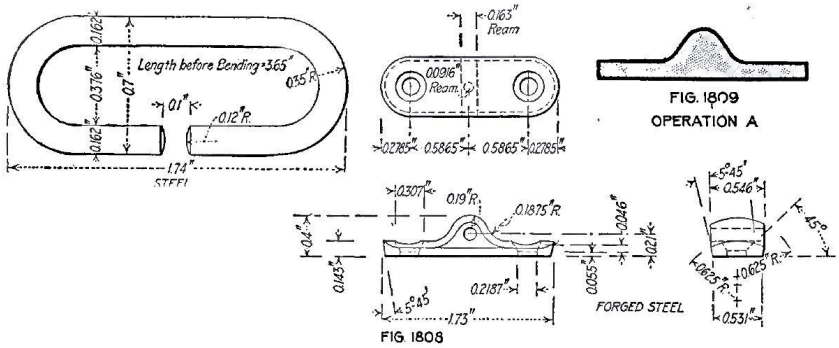


FIG. 1808

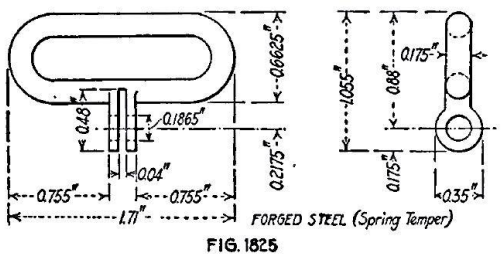


FIG. 1825

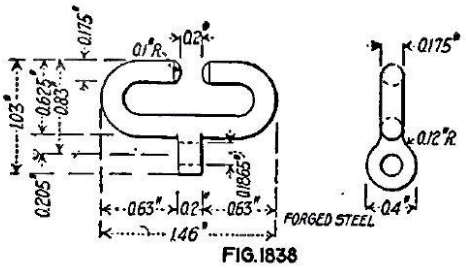


FIG. 1838

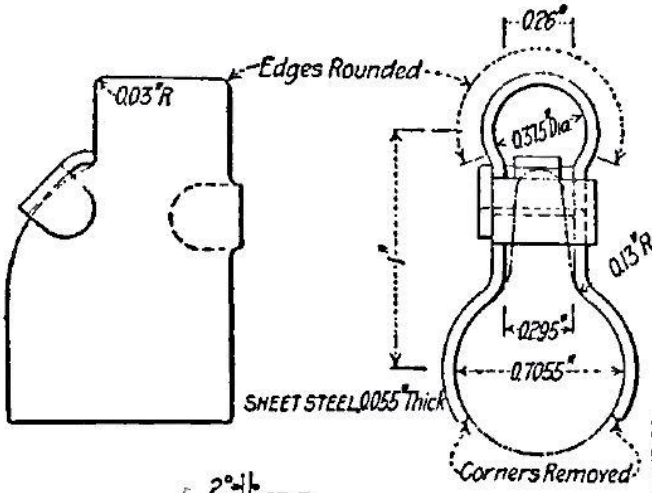


FIG.1857 OPERATION 1
FIG.1858 & 1859 OPERATION 1½
FIG.1860 & 1861 OPERATION 2
FIG.1862 & 1863 OPERATION 3
FIG.1864 & 1865 OPERATION 4
FIG.1866 & 1867 OPERATION 5

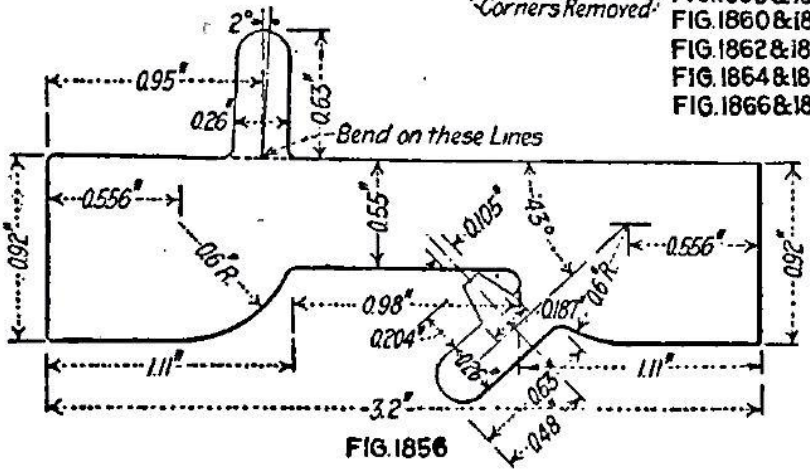


FIG.1856

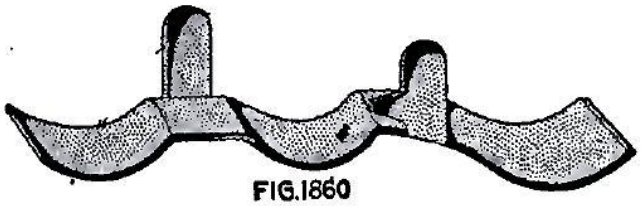


FIG.1860

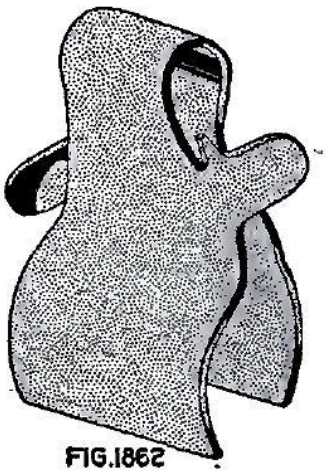


FIG.1862

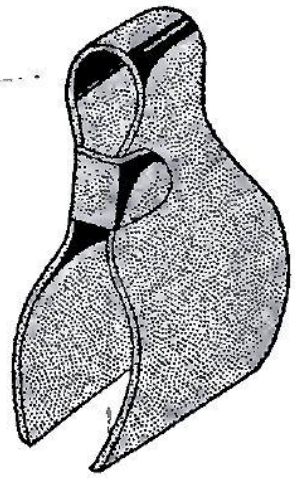
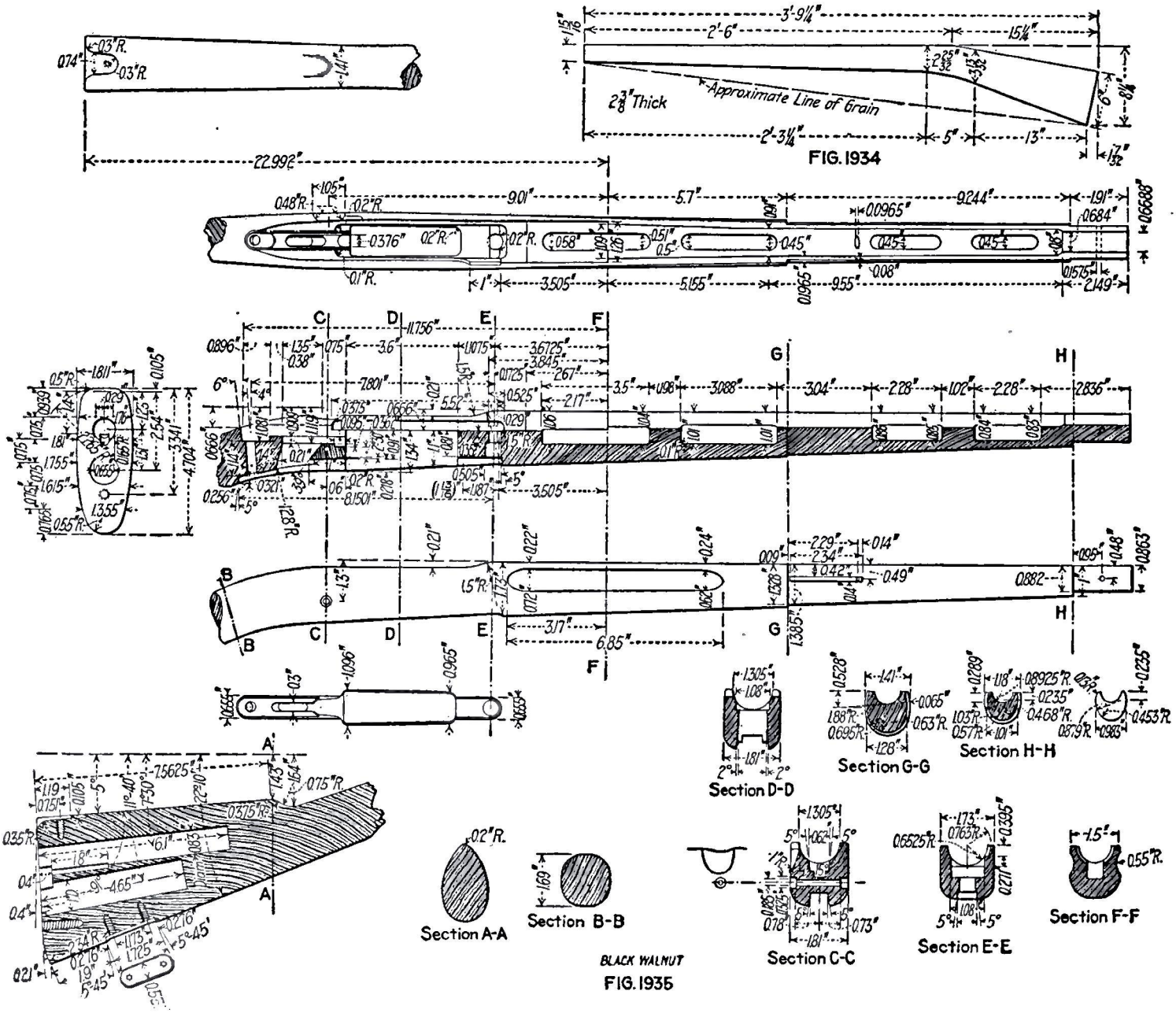


FIG.1864

Front sight guard



BLACK WALNUT

FIG. 1934

FIG. 1935

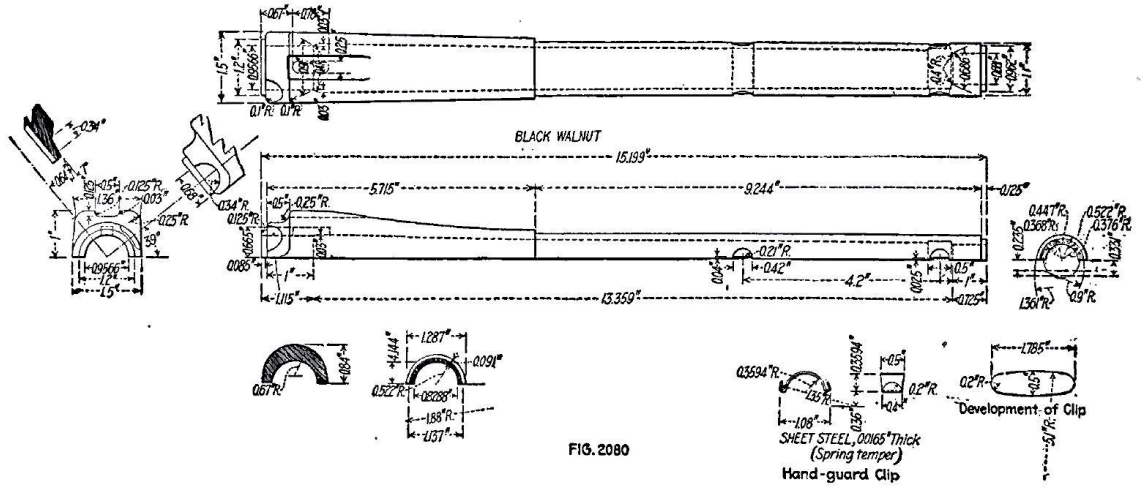


FIG. 2080

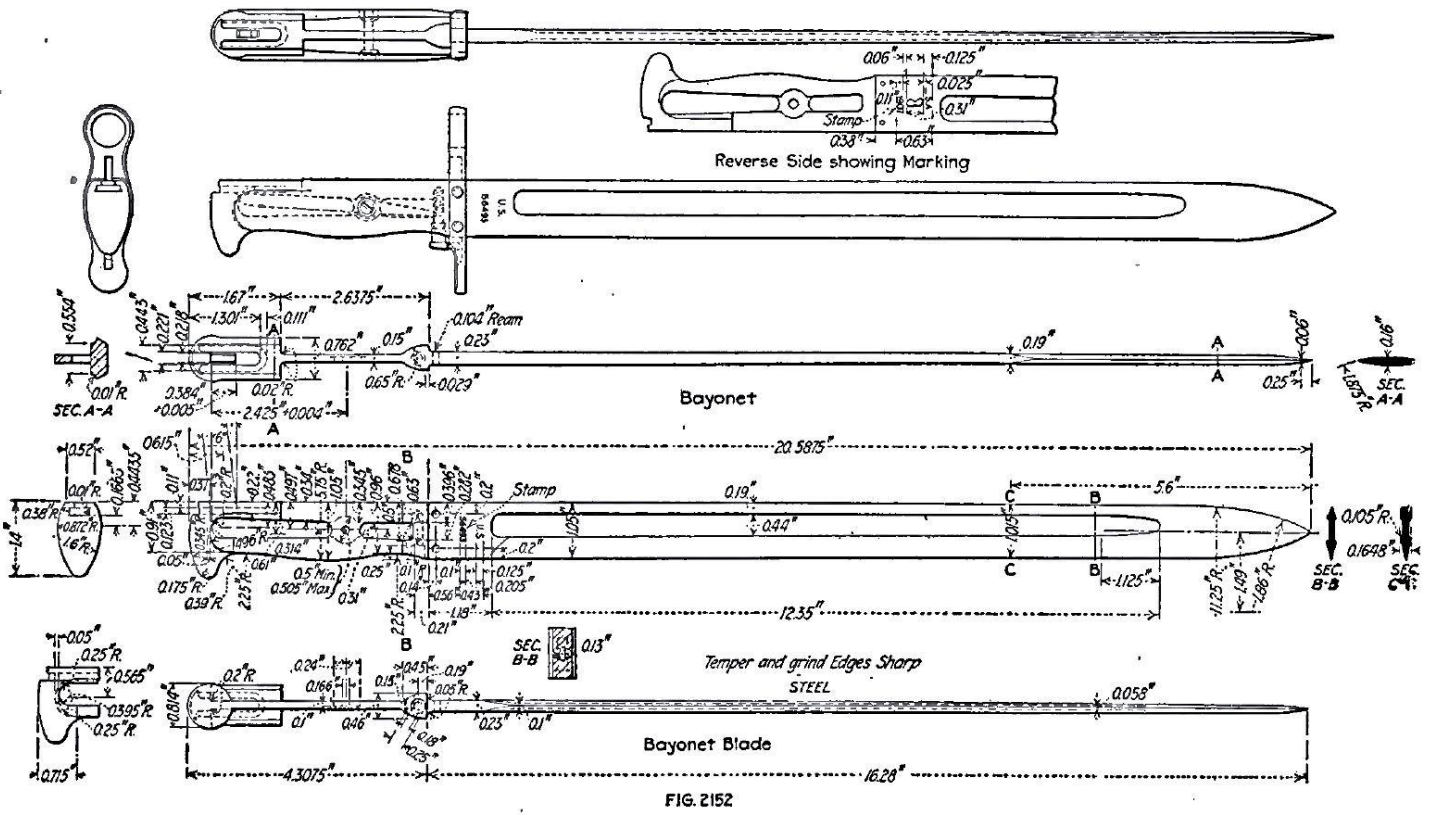


FIG. 2152

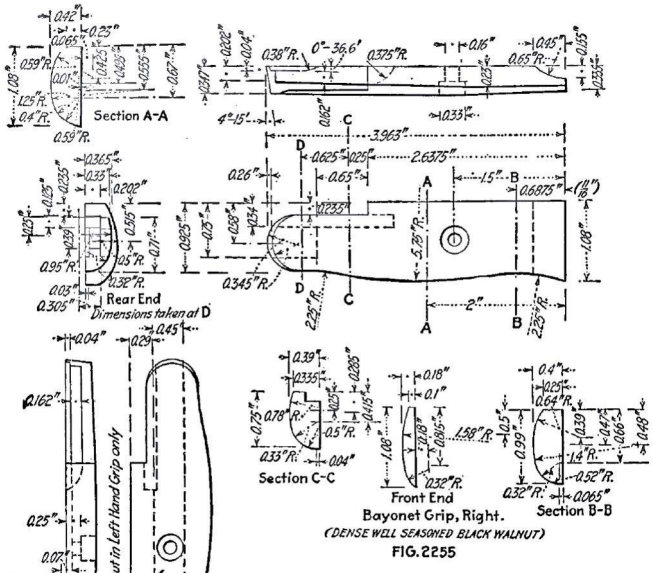


FIG. 2255

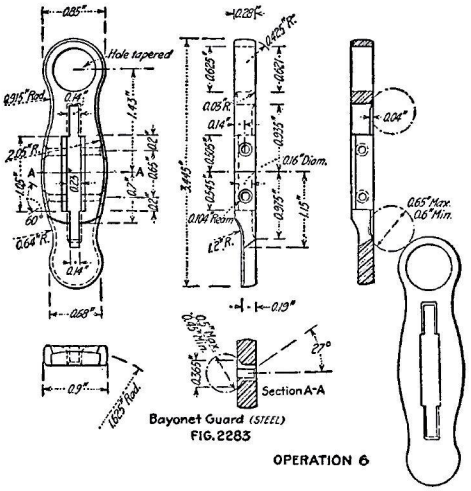


FIG. 2283

OPERATION 6

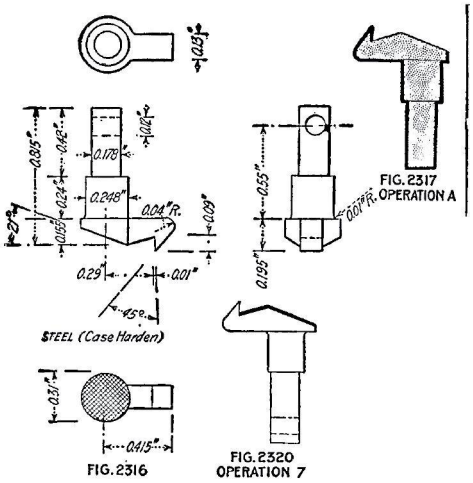


FIG. 2316

FIG. 2317
OPERATION A

FIG. 2320
OPERATION 7